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NEW CLAIMS

1. A method for producing an embossed sheet material comprising at least two layers of web material (V1, V2; V1, V3) joined together, including the steps of:

- 10 - embossing a first layer of web material (V1), previously furnished with a background pattern made up of a first set of protuberances (P2; P102; P5), so as to generate on it a second set of protuberances (P4; P104; P5), which are partially superimposed on the first set of protuberances making up the background pattern, and defining an ornamental motif made up of a
- 15 pattern of major dimensions and minor density with respect to the background pattern;

- to couple by means of glue (C) to said first layer of web material (V1) at least a second layer of web material (V2; V3),

characterized in that said glue (C) is applied in areas corresponding to at least

20 some of the protuberances of said second set of protuberances (P4; P104; P5), the sheet material being substantially free of glue in correspondence of the protuberances of said first set of protuberances (P2; P102; P1) forming said background pattern.

2. Method as claimed in claim 1, characterized in that said background

25 pattern on the first layer of web material (V1) is obtained by means of embossing in line and before the embossing of the first layer (V1) for generating of said ornamental motif.

3. Method as claimed in claim 1 or 2, characterized by embossing said

30 second layer of web material (V3) for generating therein a third set of protuberances (P6; P106) having major dimensions and minor density with respect to the protuberances (P2; P204) of the first set.

4. Method as claimed in claim 3, characterized in that the protuberances of the second and third sets (P4, P6; P104, P106) have the same density and are inserted inside one another.

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5. Method as claimed in claim 2, characterized in that it involves generating said first set of protuberances (P2; P102) and said second set of protuberances (P4; P104) on the first layer (V1) by running said first layer (V1) around a first pressure roller (5; 105) interacting with a first and a second embossing cylinders (1; 3; 101; 103) that have respectively first and second sets of points (1P, 3P; 101P, 103P), the second set of points (3P; 103P) being of larger dimensions and lower density than the first set of points (1P; 101P).

6. Method as claimed in claim 5, characterized in that it involves joining together said first and said second layers (V1, V2) between the first pressure roller (5; 105) and a second embossing cylinder (3; 103) that interacts with the first pressure roller (5; 105).

7. Method as claimed in claim 5 or 6, characterized in that said second embossing cylinder (3) interacts with a second pressure roller (7) to generate said third set of protuberances (P6) on said second layer (V2).

8. Method as claimed in one or more of claims 3 to 7, characterized in that it involves applying a glue to at least some of the protuberances of said third set (P6) on said second layer (V2), and joining said two layers (V1, V2) by gluing them together, with the protuberances of said third set (P6) in correspondence of the protuberances of said second set (P4).

9. Method as claimed in one or more of claims 3 to 8, characterized in that it involves embossing said second layer (V2) with a greater embossed depth than the embossed depth of the second set of protuberances (P4) on the first layer (V1).

10. Method as claimed in claim 5, characterized in that it involves running said second layer (V2) around said first pressure roller (105), downstream of the area in which the first layer (V1) is embossed between said first embossing cylinder (101) and said first pressure roller (105), and embossing said second layer (V2) on said first layer (V1) between the first pressure roller (105) and the second embossing cylinder (103).

11. Method as claimed in claim 10, characterized in that it involves: arranging a second pressure roller (107) around the second embossing cylinder (103); and feeding a third layer of web material (V3) around said second pressure roller (107), between the latter and the second embossing cylinder (103).

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so as to generate a fourth set of protuberances (P108) on it; the first, second and third layers (V1, V2, V3) being laminated together between the second embossing cylinder (103) and the second pressure roller (107).

12. Method as claimed in claim 11, characterized in that it involves applying a glue (C) to at least some of the protuberances of said second set of protuberances (P104) and gluing together the three layers (V1, V2, V3) by causing the glue (C) to migrate through the first layer (V1) toward the second layer (V2).

13. Method as claimed in claim 3 or 4, characterized in that it involves generating said first set of protuberances (P2) by means of a first embossing cylinder (1') with its own pressure roller (5'), and generating said second set of protuberances (P4) with another pressure roller (5) and a second embossing cylinder (3), with which latter a third pressure roller (7) interacts, the second embossing cylinder and the third pressure roller generating said third set of protuberances (P6) on said second layer (V2).

14. Method as claimed in claim 1, characterized in that said second layer of web material (V3) is furnished with a background pattern made up of a set of protuberances (P3).

15. Method as claimed in claim 13, characterized in that said background pattern of the second layer of web material (V3) is obtained by means of embossing in line and before the coupling with the first layer of web material (V1).

16. Method as claimed in claim 14 or 15, characterized in that the protuberances (P1, P3) of said background pattern on the first and on the second layer and the protuberances (P5) of said ornamental motif on the first layer project on the same face of the corresponding layer (V1, V3).

17. Method as claimed in claim 16, characterized in that the protuberances forming said ornamental motif have a greater height than that of the protuberances forming said background pattern, and in that said two layers are joined together by gluing at the positions of the protuberances (P5) of said ornamental motif.

18. Method as claimed in claim 14, 15, 16 or 17, characterized in that said first and said second layers are separately embossed by means of corre-

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sponding first embossing units (301-303, 305-307; 201-203, 205-207), which generate the set of protuberances forming the background pattern on the two layers (V1, V3), and are then run around an embossing cylinder (209; 309) provided with points (209P; 309P) for generating said ornamental motif on the first (V1) of said layers and for joining the layers.

19. Method as claimed in claim 18, characterized in that one (V1) of said layers is embossed according to said background pattern between a pair of rollers (401, 403) of a first embossing unit and is subsequently embossed on an embossing cylinder (409) provided with points (409P) for generating said ornamental motif; in that the second layer (V3) is embossed between a further embossing cylinder (421) and a pressure roller (423), said further embossing cylinder being provided with points (421P) for generating said background pattern on the second layer (V3); and in that the two layers are joined between said two embossing cylinders (409, 421).

20. Method as claimed in one or more of claims 14 to 19, characterized in that said layers (V1, V3) are joined together by means of a colored glue.

21. An embossed laminar product comprising at least two layers of web material (V1, V2; V1, V3) wherein a first (V1) of said layers of web material has a background pattern made up of a first set of protuberances (P2; P102; P1), on which is superimposed an ornamental motif made up of a second set of protuberances (P4; P104; P5) of major dimensions and minor density with respect to the first set of protuberances, and in which to said first layer (V1) is coupled a second layer of web material (V2; V3) by means of glue (C); characterized in that said glue is applied in correspondence of said second set of protuberances (P4; P104; P5) the protuberances of said first set (P2; P102; P1) forming said background pattern being substantially free of glue:

22. Sheet product as claimed in claim 21, characterized in that said two layers (V1, V2) are glued together by a colored glue.

23. Sheet product as claimed in claim 21, or 22, characterized in that said second layer of web material (V2; V3) is embossed.

24. Sheet product as claimed in claim 22, characterized in that said second layer (V2) has an embossing comprising a third set of protuberances (P6; P106) of major dimensions and minor density with respect to the protu-

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berances of said first set of protuberances (P1; P102) defining the background pattern on the first layer (V1).

25. Sheet product as claimed in claim 24, characterized in that the protuberances of said first set (P2; P102) are squeezed at the positions of the protuberances of said second set of protuberances (P4; P104) of the first layer (V1).

26. Sheet product as claimed in claim 24 or 25, characterized in that said protuberances of the third set of protuberances (P6; P106) on the second layer (V2) are inserted inside the protuberances of said second set of protuberances (P4; P104) on said first layer (V1).

27. Sheet product as claimed in one or more of claims 24 to 26, characterized in that the protuberances of the third set of protuberances (P6; P106) on the second layer (V2) are higher than the protuberances of the second set of protuberances (P4; P104) on the first layer (V1).

28. Sheet product as claimed in one or more of claims 24 to 27, characterized in that said two layers are glued together on at least some of the protuberances of the third set of protuberances (P6; P106) on said second layer (V2).

29. Sheet product as claimed in one or more of claims 24 to 27, characterized in that it comprises a third layer (V3) joined to the first and second layers (V1; V2) at the protuberances of the second set of protuberances (P104) of said first layer (V1).

30. Sheet product as claimed in claim 29, characterized in that said third layer (V3) is embossed with a fourth set of protuberances (P108) arranged with the same pattern as the protuberances of the third set of protuberances (P106) on said second layer (V2), but not so high.

31. Sheet product as claimed in claim 29 or 30, characterized in that said third layer (V3) is glued to said first layer (V1) on at least some of the protuberances of said second set of protuberances (P104).

32. Sheet product (N) as claimed in claim 23, characterized in that said second layer (V3) comprises at least one background embossing consisting of a plurality of third protuberances (P3) having minor dimensions and major density with respect to said ornamental motif.

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33. Sheet product as claimed in claim 32, characterized in that the protuberances of each layer project from the surface of the corresponding layer facing the interior of the sheet material.

34. Sheet product as claimed in claims 32 to 33, characterized in that said third protuberances (P3) in said second layer (V3) are squeezed at the positions of the second protuberances (P5) of the first layer, forming said ornamental motif.

35. Sheet product as claimed in claim 34, characterized in that, where it meets the protuberances (P5) forming said ornamental motif in the first layer (V1), said second layer (V3) has protuberances on the surface opposite that facing the first layer (V1).

36. A device for the production of a web material (N) made up of at least two layers (V1, V2; V1, V3), comprising:

- a first embossing unit for generating on at least a first (V1) of said layers a background pattern made up of a first set of protuberances (P2; P102; P1);
- a second embossing unit for generating on said first layer (V1) an ornamental motif made up of a second set of protuberances (P4; P104; P1) of major dimensions and minor density with respect to the protuberances (P2; P102; P1) of said first set and partially superimposed on said background pattern;
- a glue applicator for applying a glue for coupling a second layer to said first layer;

characterized in that said glue applicator applies said glue on the protuberances (P4; P104; P5) of said second set, but not on the protuberances of said first set forming said background pattern, and cooperates with said second embossing unit.

37. Device as claimed in claim 36, characterized by a first pressure roller (5; 105) which is common to said first and said second embossing unit interacting with a first and a second embossing cylinders (1, 3; 101; 103) carrying respective points (1P, 3P; 101P, 103P) on their cylindrical surfaces for generating on the first layer (V1) said first and said second sets of protuberances.

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38. Device as claimed in claim 37, characterized in that the points (1P; 101P) of the first embossing cylinder (1; 101) have greater density and smaller dimensions than the points (3P; 103P) of the second embossing cylinder (3; 103).

5 39. Device as claimed in claim 38, characterized in that it comprises a second pressure roller (7; 107) interacting with the second embossing cylinder (3; 103).

40. Device as claimed in claim 36, characterized in that said first embossing unit comprises a first pressure roller (5') interacting with a first embossing cylinder (1') and that said second embossing unit comprises a second embossing cylinder (3) interacting with a second and a third pressure rollers (5, 7).

41. Device as claimed in claim 36, characterized in that it comprises:
- a further embossing unit (305, 307; 421, 423; 205, 207), for a second layer (V3), said first embossing unit and said further embossing unit generating in said first and said second layers a background pattern consisting of a first set of protuberances (P1; P3).

42. Device as claimed in claim 41, characterized in that said means for coupling together said two layers join the two layers at the positions of the protuberances of the second set of protuberances which form said ornamental motif.

43. Device as claimed in claim 41 or 42, characterized in that said first embossing unit and said further embossing unit for generating said background pattern on the first and on the second layer (V1, V3) each comprise a pair of embossing rollers, one of which (1, 5; 201, 205) is provided with points (1P, 5P; 201P, 205P) while the other (3, 7; 203, 207) is provided with a yielding surface.

44. Device as claimed in claim 41 or 42, characterized in that said means for coupling said two layers consist of an embossing cylinder (9; 209) of the second embossing unit and a marrying roller (13; 213), said embossing cylinder (9; 209) being provided with points (9P; 209P) for generating the second set of protuberances forming said ornamental motif.

45. Device as claimed in claim 44, characterized in that said marrying

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roller (13) has a substantially rigid cylindrical surface.

46. Device as claimed in claim 41 or 42, characterized in that the first embossing unit for the first layer (V1) comprises a pair of embossing rollers (401, 403); in that the second embossing unit comprises an embossing cylinder (409), provided with points (409P) for generating the second set of protuberances (P5) forming said ornamental motif, and interacting with a pressure roller (411); and in that the further embossing unit (421, 423) for the second layer (V3) comprises a further embossing cylinder (421) provided with points (121P) and interacting with a pressure roller (423) having a yielding surface.
- 10 47. Device as claimed in claim 46, characterized in that said means for coupling said layers consist of said two embossing cylinders (409, 421), which form between them a lamination area in which the points (409P, 421P) of the two embossing cylinders interact with each other.
- 15 48. Device as claimed in one or more of claims 36 to 47, characterized in that said second embossing unit has an embossing cylinder (309; 409; 209) with interchangeable points (309P, 409P, 209P).
49. Device as claimed in claim 41, characterized in that the first embossing unit (301, 303) for the first layer (V1) comprises a roller (301) provided with points (301P) and interacting with a pressure roller (311) covered with yielding material, which interacts with an embossing cylinder (309) of the second embossing unit (309, 311).
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